Work Order ID 51339

August 19, 2009 11:34:47 AM

Item ID: D3827-041
Revision ID: A
Item Name: Rib Assembly (Inboard)

Accept

Setup **Start**
Stop

Start Date: 08/19/2009 **Start Qty:** 6.00
Required Date: 08/25/2009 **Req'd Qty:** 6.00
Reference:

Cust Item ID:
Customer:

Run **Start**
Stop

Approvals: **Process Plan:** MF **Date:** 09-08-19 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3827	Rev A								
100		0.00							
Large Fab	Large Fab					6			
Large Fab	**Memo**	0.00							
Large Fab	1- cut D3827-1 rib as per dwg D3827□2- drill holes using DT9435 jig and open to finish size as per dwg D3827□3- c'sink as per dwg□4- remove identification markings□5- deburr								
110	QC5- Inspect part completeness to step on W/O	0.00							
QC						6			
Quality Control	**Memo**	0.00							
120		0.00							
Large Fab	Large Fab								
Large Fab	**Memo**	0.00							
Large Fab	1- weld bushing in rib as per dwg D3827 □ A/R ER316 S.S. Rod Batch: M109213 □2- grind weld flush □3- deburr if necessary								

SAD 09-08-20

=> S 09/08/20

09-08-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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August 19, 2009 11:34:47 AM

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Start Date: 08/19/2009 **Start Qty:** 6.00
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Reference:

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Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC10 Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00	=> S 08/08/24			6	0		
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	=> S 08/08/24			6	0		
150 Packaging Packaging	Identify as per dwg & Stock Location: Basket Memo	0.00 0.00	PD 09.08.25			6			

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NOTE: Date & initial all entries

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Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00	09/08/26				09-8-25		
QC Quality Control	Memo	0.00							

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

August 19, 2009 11:34:46 AM

Work Order ID: 51339

Parent Item: D3827-041RevA

Parent Item Name: Rib Assembly (Inboard)

Comments:

Start Date: 08/19/2009 **Required Date:** 08/25/2009

Start Qty: 6.00 **Required Qty:** 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3759-1RevA Bushing		Manufactured	No			100	Each	58.0000	18.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
WA	58	
50000	22	
51136	36	

CPL 09-08-24 (16) ✓
CPL 09-08-24 (2) ✓

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065 304 SQ Tube .75x.75x.065W		Purchased	No			100	f	1,352.362	50.5263			

SAO 09-08-20

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	6.307103691	
112051	-0.7368363	
112263	7.04394	
Main Warehouse		
WA	1346.0554	
112263	1.6735	
112344	344.3819	
112398	1000	

50.5263

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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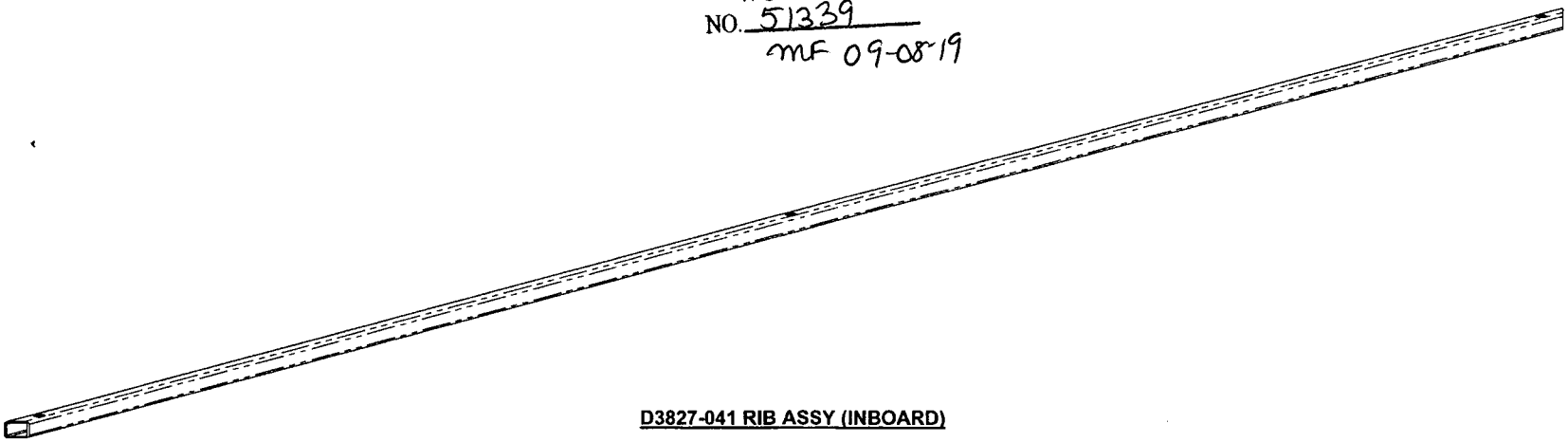
ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51339
MF 09-08-19



D3827-041 RIB ASSY (INBOARD)

RELEASED
08/11/18

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.59 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	MB	08.09.23

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.09.23

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3827 REV. A
SHEET 1 OF 3
TITLE RIB ASSY (INBOARD)
SCALE NTS

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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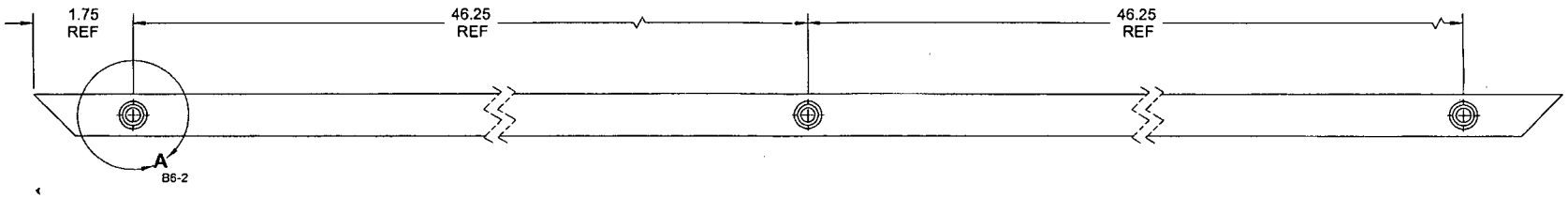
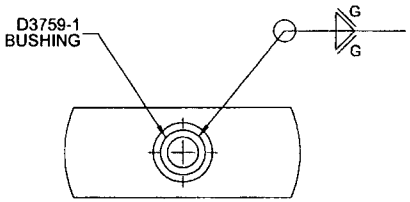


D3827-041 RIB ASSY (INBOARD)



DETAIL A C7-2
SCALE 2X
3 PL

51339

RELEASED
08/11/18

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3827 — REV. A — SHEET 2 OF 3
MFG. APPR.		
APPROVED		TITLE RIB ASSY (INBOARD) — SCALE NTS
DE APPR.		
DATE 08.09.23		

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Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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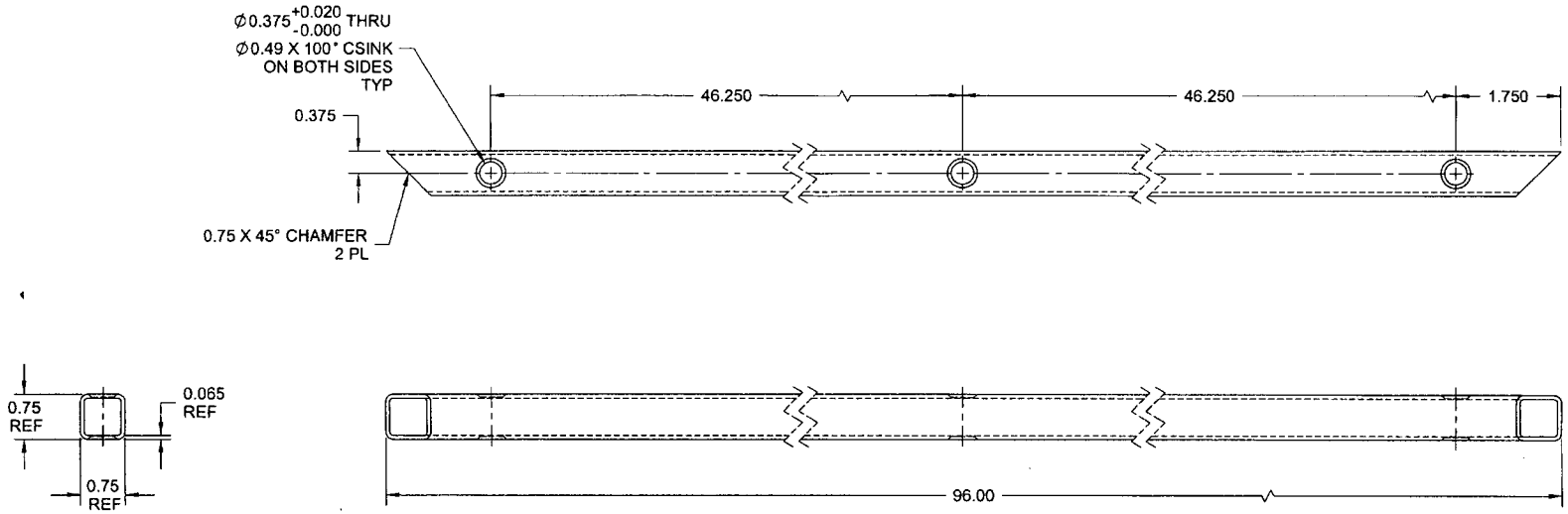

D3827-1 RIB

5339

RELEASED 08/11/18 MP

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.55 lbs

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3827 — REV. A — SHEET 3 OF 3
MFG. APPR.		
APPROVED		TITLE: RIB ASSY (INBOARD) — SCALE: NTS
DE APPR.		
DATE	08.09.23	

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Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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